

Work Order ID 56100

February 10, 2010 12:16:30 PM



Page 1

Item ID: D3523-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Leg

10
9/10

Start Date: 2/10/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: /

Date: 10-210 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D3523

Rev B

Hardinge
Hardinge CNC LATHE SMALL

100



Hardinge

Hardinge CNC Lathe Small

110



QC

Quality Control

120



Mill Conv

Conventional Milling Machine

QC2- Inspect parts off machine FAI/FAIB

0.00

SA 10/02/27

17 6

Memo

0.00

SA 10/02/27

17 6

CONVENTIONAL MILLING MACHINE

0.00

SA 10/03/03

V 6

Memo

0.00

Drill For Helicoil & Set-Screw
Use e-mill to pilot hole to avoid drill deviation*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

SL 10/03/03

17 Ø

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

MMJ
10/03/04

17 Ø

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

SL 10/03/04

X(R) Ø

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Leg

Stop



Start Date: 2/10/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC3- Inspect Part Finish

0.00

PL 10-03-46

(17)



QC

Memo

0.00

Quality Control

180

CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Memo

Conventional Milling Machine

0.00

PL 10/03/08

190

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S1063/08

(17)

W/O:		WORK ORDER CHANGES					
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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February 10, 2010 12:16:30 PM

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Revision ID:

Stop



Item Name: Leg

Start Date: 2/10/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

Identify as per dwg & Stock Location: 68

0.00

Packaging

Memo

0.00

10/03/9 (17)

210



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/03/11 HJ

MF
10-3-9

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

Page 1

February 10, 2010 12:16:34 PM

Work Order ID: 56100



Parent Item: D3523-3



Parent Item Name: Leg

Start Date: 2/10/10

Required Date: 2/26/10

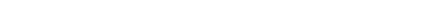
Comments: IPP Rev:A New Issue 07-06-15 EC
IPP Rev:B Added Helicoil 07-07-19

JLM Verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21209-F120		Purchased		No		100	Each	38.0000	6.0000			



HELI COIL

Warehouse <u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>	
	Main Warehouse			
ST 1114037 107823	38			
	38			
M6061T6R1.000	Purchased	No	180 f	53.0524 0.7326

ROUND BAR 1.00"

Warehouse <u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>	
	Main Warehouse			
MAT	53.0524			
108876	8.355			
110966	11.6274			
113457	33.07			

x10

Feb 10.03.05

1.827 5A 10/02/28

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DART AEROSPACE LTD	Work Order:	56100
Description: Leg	Part Number:	D3523-3
Inspection Dwg: D3523	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SA</u>	Audited by:	<u>MNP</u>	Prototype Approval:	N/A
Date:	<u>10/02/27</u>	Date:	<u>10/02/28</u>	Date:	N/A

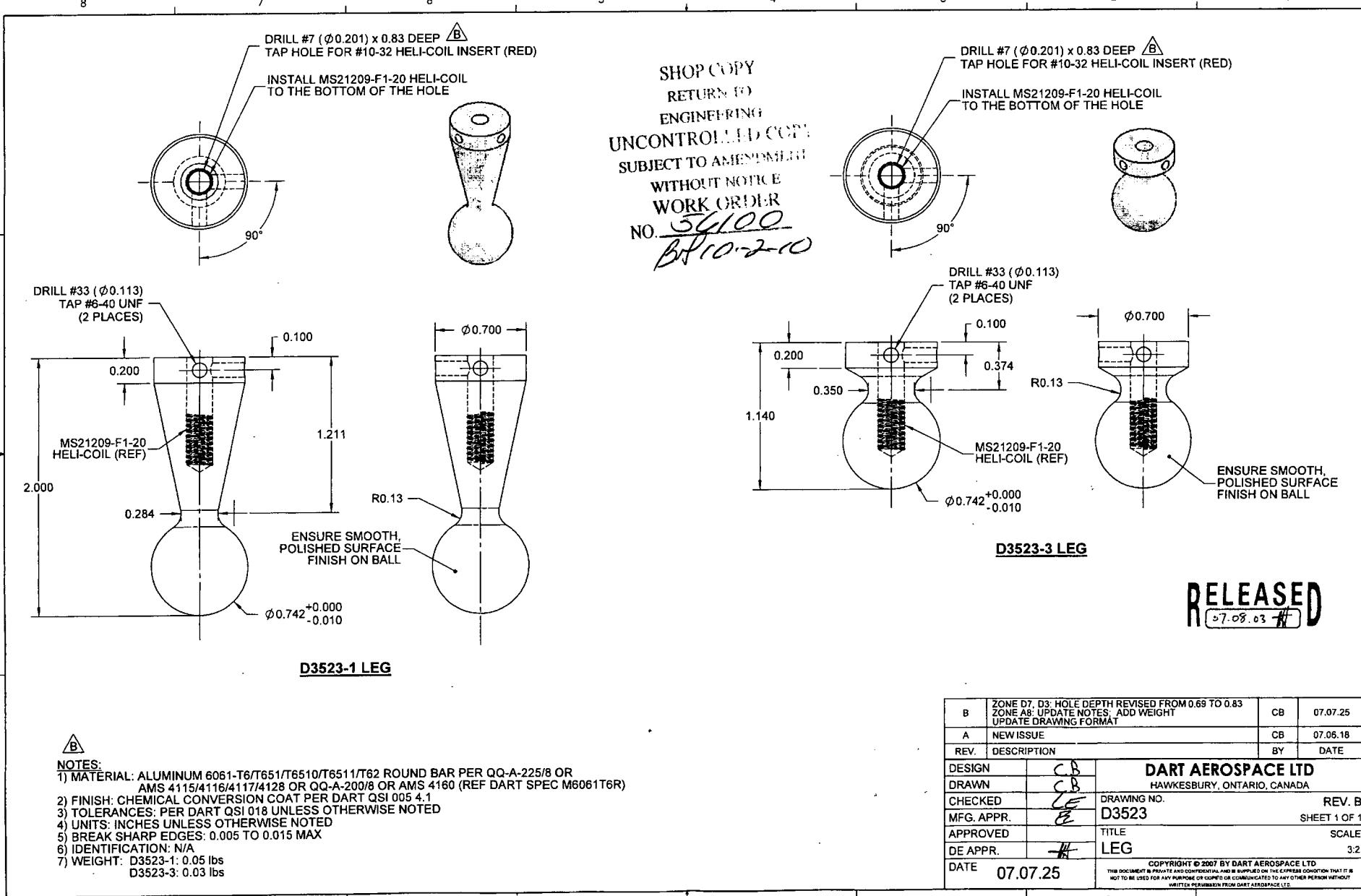
Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	DS

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